

Work Order ID 137042

137042

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Wednesday, September 23, 2015 1:03:18 PM

Item ID: D5305-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Shim
 Start Date: 9/23/15 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 9/25/15 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: H Date: 15-9-23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5305	A

100 0.00

100 FLOW WATER JET 3740 EL 15-9-23

Waterjet Memo 0.01

FLOW CNC Waterjet 1-Cut as per Dwg

Dwg Rev: 5

Prog Rev: 15

2-Deburr if necessary

110 0.00

110 QC2- Inspect parts off machine FAI/FAIB 3740 EL 15-9-23

QC Memo 0.01

Quality Control

120 0.00

120 QC8- Inspect parts - second check (40)

QC Memo 0.01

Quality Control

DAS
38
9-23-15
SEP 23 2015

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N900040100

Setup Start *NS1*

Stop ***NS2***

40

40

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

130

0.00

**DAS
30
9-89**

40

~~SEP 23 1955~~

Memo

FORM AS PER DWG

0.00

140

Memo

0.01

Quality Control

⑤

15.09.23 PD.

0.00

150

Memo

0.00

Hand Finishing

40

FF

Sept. 24-2015

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 Item Name: Shim
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 Required Date: 9/25/15 Req'd Qty: 40.00 *40* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>SH124</u>	0.00				DAS 6 40989			
190									
Packaging	Memo	0.00							SEP 25 2015
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00				MLS			SEP 25 2015
Quality Control									

20150925
 SH

Picklist Print

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Work Order ID: 137042

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Parent Item: D5305-1

D5305-1

Parent Item Name: Shim

Start Date: 9/23/15

Required Date: 9/25/15

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP REV:A 15.09.04 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.050

Purchased

No

sf

190.3777

3.368421

M6061T6S 050

**

Q 15-9-23

6061-T6 .050 Sheet

Location

Loc Qty

Loc Code

MAT021

190.3777

125636

11.3777

m131352

179

7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

8 7 6 5 4 3 2 1

D

D

C

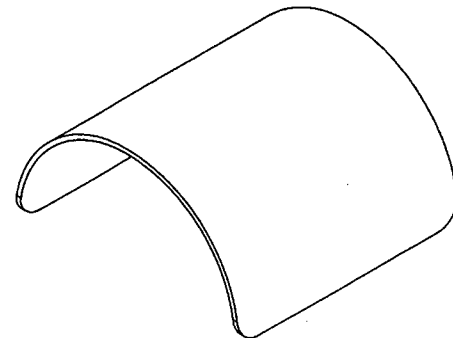
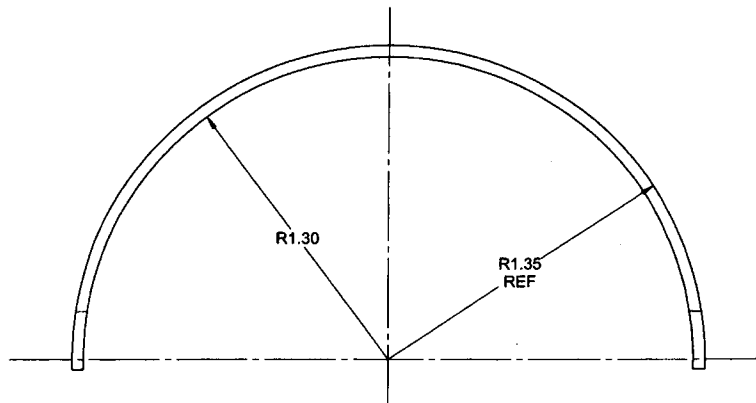
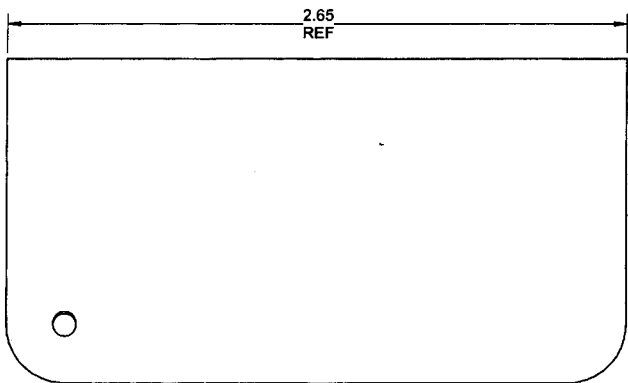
C

B

B

A

A



D5305-1 SHIM
(MAKE FROM D5305-1F)

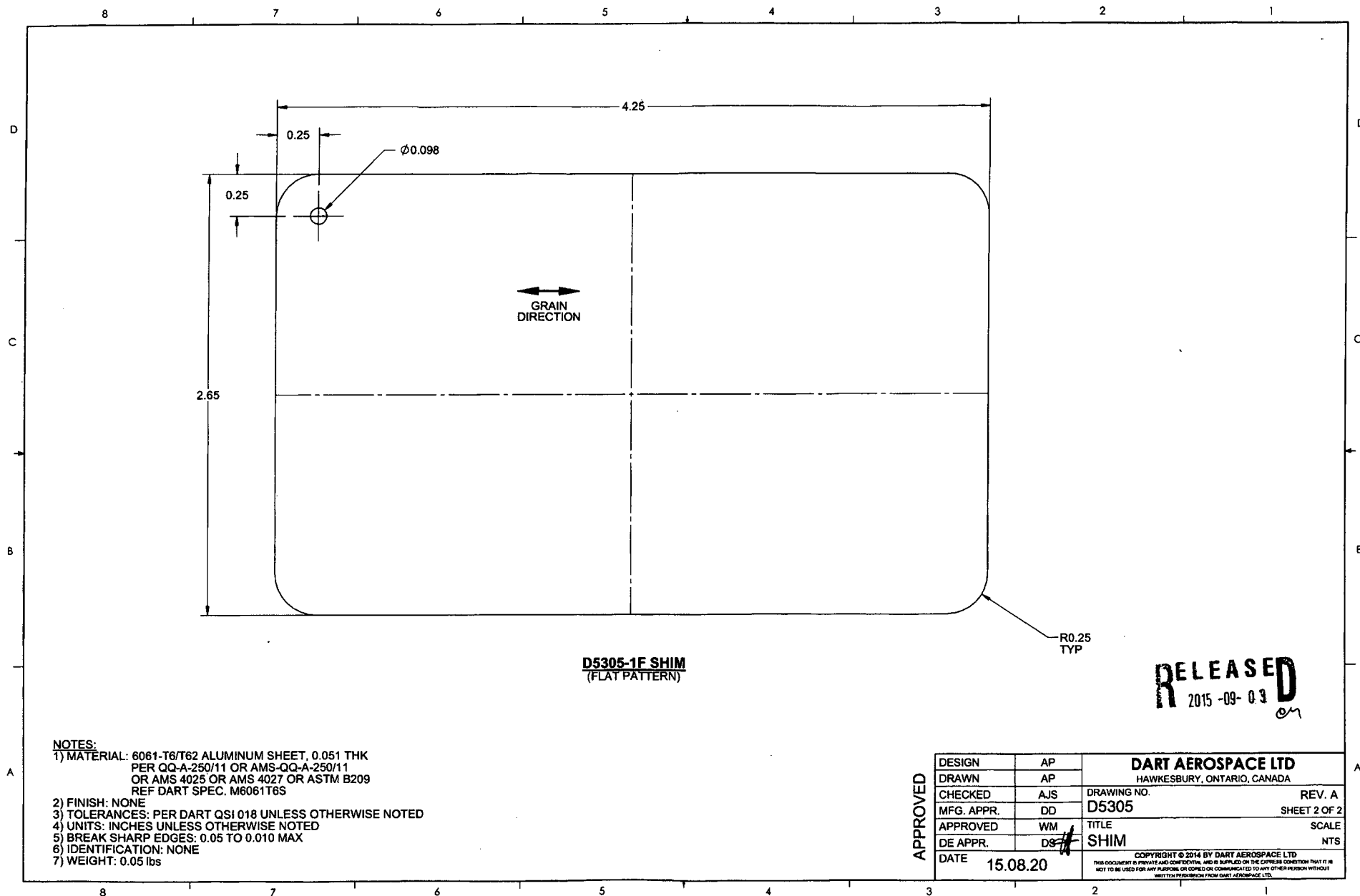
RELEASED
2015-09-03
EW 15-624

- NOTES:**
- 1) MATERIAL: MAKE FROM D5305-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER QSI 005 4.2.1
PAINT WHITE PER QSI 005 4.2.2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.05 lbs

APPROVED

A	NEW ISSUE	AP	15.08.20
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5305	SHEET 1 OF 2
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	SHIM	NTS
DATE	15.08.20	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



RELEASED
2015-09-03

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.051 THK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.05 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lbs

APPROVED	DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	AP		
	CHECKED	AJS	DRAWING NO.	REV. A
	MFG. APPR.	DD	D5305	SHEET 2 OF 2
	APPROVED	WM	TITLE	SCALE
	DE APPR.	DS	SHIM	NTS
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DART AEROSPACE LTD	Work Order	13/042
Description:	Part Number:	D5305-1
Inspection Dept:	Rev:	1 of 1